Work Orde				*109	3909*						Page 1
Item ID: Revision ID: Item Name:	D3453-1 Clevis			Accept	*N90	0040	100)* s	Setup Start	*N	S1* S2*
Start Date: Required Date: Reference:	12/05/13 12/19/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Iten Custome						
Approvals:		an: MC3	•			Date:		F	Run Start Stop	17	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr			,						
D3453	Rev	v B									
*100 *100* Doosan Lathe		Rev: <u>#A</u> Dwg D3453	er Folio FA577 Rev: <u>\$</u> per dwg D3453	0.00				12	Ø		AS 49 9-8 13/12/19
*150 *150* QC Quality Control		QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00			<i>*</i>	12	<u>Ø</u> _		13/12 //
160 *160* QC Quality Control		QC8- Inspect parts - seco	and check	0.00	B. a 13	12/20		12	<u></u>		08 08

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		auli Oudau	odata amb	AEROSPACE
CA Closed.			Date.				_			VV	ork Order up	date only	<u> </u>
Work Orde	er:					DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	
						Rework			Skid-tube C	rosstube		Water Jet	Engineering
Part N	No.					Scrap			—	mall Fab	Pro	d. Eng. Coor.	Quality
	-	•				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR f	No					Suspected Unapproved			Large Fab Co	omposite		Supplier	
Root		1			Docc	rintian of work and an undata		nitial	A ation		C: 0		
Cause	D-	ate	Step	Qty	Desci	ription of work order update or non-conformance	1	nicial ief Eng	Action Description	.	Sign & Date	Verification	OC Increator
Design		ate	step	Qty		or non-comormance	CII	ilet'EtiB	Description	וונ	Date	verincation	QC Inspector
Doc/Data	H												
Equip/Tooling	H												
Handling/Pre	\dashv												
Material													
Operator													_
Offset/Setup	П												
Process													
Supplier													
Training													
Transport						·							
Unapproved													
							FAI	JLT CAT	regory				
Landi	ng Gear					General							_
	Bend	ding				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Cent	re No	t Concer	ntric	<u> </u>	BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crac					Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
•	_	-	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqua	lified	Part Lost/Mi	ssing	Weld
	Cuff					Contamination		Instruct	ions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled
I	Crus	_				Countersink		_	ned/off center		Positioned W	Vrong	-
:	${f oxdot}$	t Treat				Cut Too Short	Ĺ	Mislabe	eled		Power Loss/	Surge	Other
	⊢ ⊣ `		Strip in	Tube		Drawing		Misread	d				
	${f oxed{f oxet}}}}}}$	ks/Cha				Drill Holes		Off-set					
	—	_	equence		<u> </u>	Finish		4	Calibration				
	l Wav	e/Twi	ist in Tub	e e	- 1	Fit/Function	1	Out of S	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Order ID 109909

December-05-13	3 2:34:14 PM	M						<u> </u>			
Item ID: Revision ID:	D3453-1			Accept	*N900	040	100)* s	etup Star	17	S1*
Item Name:	Clevis								Stop	' *N	S2*
Start Date:	12/05/13	Start Qty: 12.00	*12*		Cust Item I	D:					
Required Date: Reference:	12/19/13	Req'd Qty: 12.00	*12*		Customer:						
Approvals:	Process Pla	an:	Date:	Tooling:	Da	ate:		R	tun Star	1/1	R1*
				SPC (Y/N):		ate:			Stop	' *N	R2*
Sequence ID/ Work Center II	D	Operation Description	. 14. 0	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		Identify as per dwg & Sto	ck Location: WAO2	0.00				10	DAS		2-27
170 Packaging Packaging		Мето		0.00				ZX	9-89	3-12	-27_
rackaging									:		
180		QC21- Final Inspection -	Work Order Release	0.00				1/	2/0		/
120		Memo		0.00) XY	n_13/12	2/30 - MF
Quality Control								V)	MF
											12

(b/12-30)

DQA:		Date:					_					
QA Closed:		Date:		WORK ORDER NO	ON-CO	ONFO	RMANCE / UPDAT		ork Order up	odate only	AEROSPACE] :
 				DISPOSITION			AG		PARTMENT			
Work Orde	er:			_							, ,	
				Rework	-			sstube		Water Jet	Engineering	
Part N	10			Scrap	\vdash	1	~ 	all Fab		d. Eng. Coor.	Quality	
NICD A	1-			Use-as-is		Thern	~ 	nishing 	Rec/Stor	re/Packaging	Other	-
NCR N	NO			Suspected Unapproved			Large Fab Com	posite		Supplier	لــا ا	
Root				Description of work order upda	ate I	Initial	Action		Sign &			
Cause	Date	Step	Qty	or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
Unapproved												
					FA	ULT CAT	TEGORY			·		
Landir	ng Gear			General	_	.		_	1	_	, ,	
	Bendin	-		Bend		-1 `	Program	ļ	Outside Dim	 	Pressure/Forced	
	_	Not Conce	ntric	BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cracks			Broken/Damage/Defect		Hardwa			Part Incorre	ct	Temperature/Cure	
	— ``	Kink/Ripple	e/Wave	Burrs	_	Inspect	ion Incomplete/Unqualifie	ed	Part Lost/Mi	issing	Weld	
	Cuffs			Contamination		4	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
	Crushin	_		Countersink		7	gned/off center	· · · · · · · · · · · · · · · · · · ·	Positioned V		-	
	Heat Tr			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	Inspect	ion Strip in	1 Tube	Drawing		Misread	d					
	Marks/	Chatter		Drill Holes		Off-set						
	Turning	s Sequence	<u>:</u>	Finish		Out of 0	Calibration					
	Wave/	wist in Tul	be	Fit/Function		Out of	Sequence					

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Picklist Print

December-05-13 2:34:18 PM

Work Order ID: 109909

109909

Parent Item:

D3453-1

D3453-1

Parent Item Name: Clevis

Start Date: 12/05/13

Required Date: 12/19/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

A05.09.27New issueEC

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
изо4R1.250		Purchased	No			100	f	21.3833	0.288	4			
M304R1 04 round bar 1.250	250								**		(A0)	13/	12/11

. 0-0-	Loc Code	Loc Qty	Location
		21.3833	MAT029
		3.3	125387
4.0 (+.5)		6.0833	→ m126151
		12	m126647
/			

NOT PULLE A

DQA:			Date:			WORK ORDER NON-	cc	אוב <i>ר</i> ונ	DNANICE / I	IDDATE			DART
QA Closed:			Date:			WORK ORDER NOW		JINFOI	NIVIAIVEE / C		/ork Order u	odate only	AEROSPACE
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WOIR OIGE	' · —					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	do.					Scrap		,	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
Tutti	' '-				—	Use-as-is			noforming	Finishing	⊣	re/Packaging	Other
NCR N	No		•			Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	. A	ction	Sign &		1
Cause		Date	Step	Qty		or non-conformance	1	ief Eng		cription	Date	Verification	QC Inspector
Design										,			
Doc/Data			,										
Equip/Tooling			•										
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process							1						
Supplier													
Training													,
Transport													
Unapproved													
							FAI	ULT CAT	EGORY				
Landi	ng Ge	ar				General		_			,		
	В	ending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	L c	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
-	Cı	racks				Broken/Damage/Defect		Hardwa	re .		Part Incorre	ct	Temperature/Cure
	Cı	rimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	on Incomplete/l	Jnqualified	Part Lost/M	issing	Weld
	Cı	uffs				Contamination		Instruct	ions Incomplete	/Unclear	Part Moved		Wrong Stock Pulled
	Cı	rushing				Countersink		Misalig	ned/off center	. [Positioned V	Vrong	_
	Шн	eat Trea	t			Cut Too Short		Mislabe	eled	Γ	Power Loss/	Surge	Other
	In	spection	Strip in	Tube		Drawing		Misread	i		-	_	
	∐v	larks/Ch	atter			Drill Holes		Off-set					
	Tı	urning Se	equence			Finish		Out of (Calibration				
	\Box_{w}	/ave/Tw	ist in Tub	oe .		Fit/Function		Out of S	Seauence				

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DART AEROSPACE LTD	Work Order:	109909
Description: Clevis	Part Number:	D3453-1
Inspection Dwg: D3453 Rev: B		Page 1 of 1

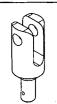
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.442	1		VERN	P40-01
R0.25	+/-0.030	. 250			Rad G	
0.450	+/-0.010	, 448			venu	PUD-12
0.625	+/-0.010	, 623			, `	* 4
0.063 x 45°	+/-0.010 x 0.5°	. 063	V		1(
Ø0.129	+0.005/-0.001	. 128	V		VERJ	P26-12
3.26	+/-0.030	3,260			11	
1.00	+/-0.030	. 998			**	11
1.550	+/-0.010	1,548	~		Mic	PMD-09
0.500	+0.010/-0.000	. 502			Venu	P40-12
0.263 x 45°	+/-0.010 x 0.5°	. 265			11	
R0.25	+/-0.010	. 251			(1)	1
	±.030					1.00a - 1.1.11
Ø1.13	+0.012/-0.00 1	1,127			• •	
Ø0.500	+0.000/-0.005	.497			i,	11
	•					

	VA					
Measured by:	40 9-89	Audited by:	D.A	OAG	Prototype Approval:	N/A
Date:	13/12/19	Date:	13/12/20) 9-80)	Date:	N/A

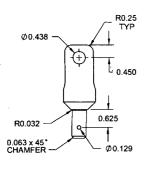
Rev	Date	Change	Revised by	Approved
Α	06.06.30	New Issue	KJ/JLM	:
В	07.01.17	Dimensions added	KJ/JLM	
С	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD L	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ KJ	24

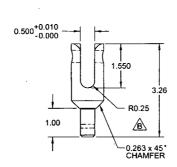


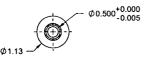
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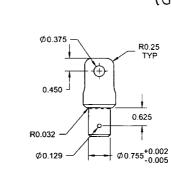
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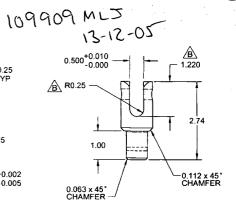






D3453-1 CLEVIS





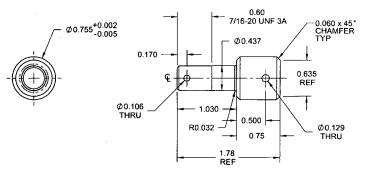


D3453-3 CLEVIS

В	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018				09.05.21
Α	NEW IS	ISSUE			05.09.02
REV.			DESCRIPTION BY DATE		
DESIG	N	RF	DART AEROSPACE LTD		
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED		W	DRAWING NO.		REV. B
MFG. APPR.		71	D3453		SHEET 1 OF 2
APPROVED			TITLE		SCALE
DE APPR.		7	CLEVIS		NTS
DATE 09.05.21			COPYRIGHT © 2005 BY DART AEROSPACE LTD. THE DOCUMENT B REWART, AND CONFEDENTIAL HOS IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS HOT TO BE USED FOR MAY PURPOSE OR COMED OR CONHUNCIACTOR DAY OTHER PERSON WITHOUT WRITTEN PERSONS I FROM COMET AEROSPACE, LTD.		

D3453-1/-3 NOTES:
1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

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		:
4 ay		



D3453-5 PLUG

D

D3453-5 NOTES:

1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.13 lbs

DESIGN RF DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3453 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE **CLEVIS** DE APPR. NTS COPYRIGHT © 2005 BY DART AEROSPACE LTD

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WHITE THE PERSONS ON FROM DART ASSESSMENT LTD. DATE 09.05.21

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